-,	ID 70	2024		1 (\$1(1) 2)(1)							
Work Orde Thursday, May 2											Page 1
Item ID: Revision ID:	D4020-11			Accept				S	etup Sta	rt	
Item Name:	End Mesh, Ba	asket							Sto	р	
Start Date: Required Date: Reference:	5/20/2010 5/26/2010	Start Qty: 6.00 Req'd Qty: 6.00	1 Jania ani 1881 1 Jania ani 1881		Cust Item I Customer:	D:				11881(18)	
Approvals:	Process Pla	an:	Date: 1052	Tooling:	Da	 ite:_	_	F	lun Sta	rt	
	QC:	/(Date:	_ SPC (Y/N):		ite:			Sto	P	
Sequence ID/ Work Center ID).	Operation Description		Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Rev	vision Nbr									
D4020	A										
		FLOW WATER JET		0.00				-D 10	- = >>/	·_	
Waterjet FLOW CNC Waterje	t	Memo 1-Cut as pr Dwg Rev:_ Prog Rev:_ 2-Deburr i	1	0.00				W (0	<u>-5-30</u>	B(()
110 		QC2- Inspect parts off	machine FAI/FAIB	0.00					_		
		Memo		0.00				B10-	<u> </u>	•	-
120		QC8- Inspect parts - sec	cond check	0.00							

25/20/00 2 00.0

Quality Control

Memo

Dart Aerospace Lt	td	L	•	CE	a	0	S	ro	e	Α	art	D
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W/O:			W	ORK ORDER CHANG	GES				vî •
DATE	STEP	PRO	OCEDURE CH	ANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
							!		
Part No		PAR #:							
	Res	solution:						Date:	
NCR:	NCR:		WORK ORI	DER NON-CONFORM	ANCE (NCF	R)			
DATE	STEP	Description of NC Section A	Initial Chief Eng	Corrective Action Sec Action Description Chief Eng	tion B Sign & Date	Verific Secti	cation on C	Approval Chief Eng	Approval QC Inspector
									-
									,
							,		

Work Order ID 58931

Thursday, May 20, 2010 8:55:30 AM



Page 2

Item ID:

D4020-11

Accept

Setup Start



Revision ID:

Item Name:

End Mesh, Basket

Start Date: Required Date: 5/26/2010

5/20/2010

Start Qty: 6.00

Req'd Qty: 6.00



Cust Item ID:

Customer:

Draw

Number

Reference:

Approvals:

Process Plan:

QC:

Date:

Date:

Tooling: SPC (Y/N):

Set Up/

Run Hours

Date: Date:

Draw

Rev.

Accept

Qty

Run

Start Stop

Stop

Sequence ID/

Work Center ID

130

Packaging

Packaging

Operation Description

Identify as per dwg & Stock Location: WA

Memo

Memo

0.00

Plan

Code

Reject **Qty**

Reject Insp. Number

Stamp

140

OC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

0.00

10/06/01 Af-unf 10-5-27

	Dart	Aeros	pace	Ltd
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W/O:			W	ORK ORDER CHAN	GES				4 4
DATE	STEP	PR	OCEDURE CHA	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No		PAR #:							
_	Re	esolution:	Dispositio	n:	QA: N/C C	losed:		Date: _	
NCR:		•	WORK ORD	ER NON-CONFORM	MANCE (NC	R)			
DATE	STEP	Description of NC			ection B	Verifi	cation	Approval	Approval
DAIL	JILF	Section A	Initial Chief Eng	Action Description Chief Eng	Sign Date	& Sect	ion C	Chief Eng	QC Inspector
•		•							
	1		1			1		I .	1

Picklist Print

Thursday, May 20, 2010 8:55:37 AM

Work Order ID: 58931

D4020-11

Parent Item Name:

End Mesh, Basket

Comments:

Parent Item:

IPP RevA: new issue DD 09.11.26 verified by;EC

per dwg revA 10.03.15 verified by:EC

IPP Rev:B as

100

Start Date: 5/20/2010

Required Date: 5/26/2010

Start Qty: 6.00

Required Qty: 6.00

Component Item ID/ Item Name M304EX0.75-16F

Replacement Mfg/ Item ID Purch Purchased

Bin Primary Item Location No

Last Location

Route Unit of Seq ID sf

Qty on Measure Hand 348.1320

Qty per Kit Qty 2.694

Issued 17.

Date Issued

Status

Page 1

Expanded Metal Flat SS

1810-5-X

Location		Loc Oty	Loc Code	
MAT		348.1320368		
111956		28		·
112949		12		
113497		6.34		
113555	•	39.2888368		113
114399		108.1523		100
114594	:	154 3509		

W/O:			W	ORK ORDER CHANG	ES				· ·
DATE	STEP	PRO	OCEDURE CHA	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC inspector
			- LINDS					1 Too Wgi	
						j			
Part No		PAR #:	Fault Cate	egory:	_ NCR: Yes	No DQA	\:	Date:	
	Re	solution:						Date: _	
NCR:		•	WORK ORD	ER NON-CONFORM	ANCE (NC	3)			
DATE	STEP	Description of NC			tion B	Verific	ation	Approval	Approval
		Section A	Initial Chief Eng	Action Description Chief Eng	Sign a		on C	Chief Eng	QC Inspector
									-
				•					

DART AEROSPACE LTD	Work Order:	5863/
Description: End Mesh, Basket	Part Number:	D4020-11
Inspection Dwg: D4020 Rev: A		Page 1 of 1

	FIRS	T ARTICLE I	NSPECT	ON CH	ECKLIST		·
		First Art	icle	Prot	otype		
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Coi	nments
24.34	+/-0.030	24.34	طِ				
2.88	+/-0.030	3.80	8-				
17.31	+/-0.030	17.31	*				
15.50	+/-0.030	15.50	1/2				
20.18	+/-0.030	20.18	×	-			
5.64	+/-0.030	264	4	***************************************			
2.00	+/-0.030	200	8				
0.38	+/-0.030	.38	6				
		,					
							
easured by:	B	Audited by:			Prototype Appi	roval:	N/A
Date:	10-5-26	Date:	polustz	ا		Date:	N/A
ev Date 10.04.01	Change New Issue					sed by	Approve
. 1 10.04.01	11011 10306				KJ	-13/	16/

H:\FORMS\Quality	Assurance\approved	QA\FAI revD
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W/O:			W	ORK ORDER CHANG	GES					* •
DATE	STEP	PRO	OCEDURE CHA	NGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No:		PAR #:			•					
	n	esolution:							Date:	
NCR:			WORK ORD	ER NON-CONFORM	IANCE	(NCR)			
DATE	STEP	Description of NC			ction B		Verific	ation	Approval	Approval
	JILI	Section A	Initial Chief Eng	Action Description Chief Eng		Sign & Date	Section	on C	Chief Eng	QC Inspector (
									•	

2 23.6 D SHOP COPY RETURN TO **ENGINEERING UNCONTROLLED COPY** SUBJECT TO AMENDMENT WITHOUT NOTICE WORK ORDER 15.13 NO. 5 7.3/ R/10 5-20 15.61 19.52 R3.0 TYP (9) D4020-1 MESH (350 BASKET LONG, BASE) (SEE D4020-1F FOR LENGTH) D4020-3 (350 BASKET SHORT, BASE) (SEE D4020-3F FOR LENGTH) NOTES: 1) MATERIAL-1: MAKE FROM D4020-1F -3: MAKE FROM D4020-3F A NEW ISSUE 10.03.04 REV. DESCRIPTION DATE 2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: N/A DESIGN DART AEROSPACE LTD DRAWN HAWKESBURY, ONTARIO, CANADA CHECKED DRAWING NO. REV. A 5) BREAR SHARF CLOCES, IN/A
6) IDENTIFICATION: N/A
7) WEIGHT: SEE D4020-1F & D4020-3F
8) LOCAL TRIM MAY BE NECESSARY TO CLEAR FASTENERS/STRUCTURE SEE NEXT ASSY FOR DETAILS
9) PRE-FORMING OF MESH PER SHOP OPTION, THIS VIEW MAY BE USED FOR REF ONLY D4020 MFG. APPR. SHEET 1 OF 4 APPROVED TITLE 350 BASKET MESH (BASE) DE APPR. COPYRIGHT © 2010 BY DART AEROSPACE LTD
THEIL DOCUMENT IS PRIVATE AND COMPIDENTIAL AND AS EMPLED ON THE EXPRESS CONDITION OF THE EXPRESS CONDITION DATE 10.03.04 8 7 5

W/O:			W	ORK ORDER CHAN	GES	_				1.
DATE	STEP	PRO	OCEDURE CH	ANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	·	PAR #:	Fault Cat	egory:	NCR:	Yes N	lo DQ A	\ \:	Date:	
		esolution:								
NCR:		\	WORK ORE	DER NON-CONFORM	IANCE	(NCR)				
DATE	STEP	Description of NC	In this I		ction B	<u> </u>	Verific	ation	Approval	Approval
		Section A	Initial Chief Eng	Action Description Chief Eng		Sign & Date	Section	on C	Chief Eng	QC Inspector
										-
1										

D4020-5: 95.25 D4020-7: 56.00 D С 21.75 2.00 1.25 D4020-7 D4020-5 25.00 44.66 D4020-5 MESH (350 BASKET LONG, LID)
 (LOCAL SECTION MESH SHOWN FOR CLARITY) 9 <u>D4020-7 MESH (350 BASKET SHORT, LID)</u> (LOCAL SECTION MESH SHOWN FOR CLARITY) NOTES: NOTE: NOTES: NOT REF DART SPEC. M304EX0.75-16F

2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: N/A
6) IDENTIFICATION: N/A
7) WEIGHT -5: 0.80 lbs APPROX
-7: 4.49 lbs APPROX
8) LOCAL TRIM MAY BE NECESSARY TO CLEAR FASTENERS/STRUCTURE SEE NEXT ASSY FOR DETAILS
9) TOLERANCE ON XX.XX DIMENSIONS ± 0.06. DESIGN AJS **DART AEROSPACE LTD** DRAWN JPH HAWKESBURY, ONTARIO, CANADA DRAWING NO. CHECKED REV. A D4020 MFG. APPR. SHEET 2 OF APPROVED TITLE SCALE 350 BASKET MESH (BASE) DE APPR. NTS COPYRIGHT © 2010 BY DART AEROSPACE LTD
THIS DOGMENT IS PRIVATE AND CONTRIBUTION AND IS SUPPLIED ON THE DIFFERS CONDITION TO THE RESIDENCE OF COMPANION OF THE PRIVATE OF CONTRIBUTION OF THE PRIVATE O DATE 10.03.04 7 5

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W/O:			WC	ORK ORDER CHANC	GES					,	
DATE	STEP	PR	PROCEDURE CHANGE			,	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
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Part No:		PAR #:	Fault Cate	NCR: Yes No DQA: Date:							
·	Res	olution:	Dispositio	n:	QA: N/C Closed: Dat):	
NCR:			WORK ORDI	ER NON-CONFORM	ANCE (N	CR)					
DATE	STEP	Description of NC	Corrective Action Section Initial Action Description			Sign &		ation	Approval Chief Eng	Approval QC Inspector	
		Section A	Chief Eng	Chief Eng	Date		Section C				
										-	
		11/1/									
										<u> </u> -	

0.40 8 R1.44 15.50 2.00 0.38 5.64 75° R3.38 REF 9 D4020-11 END MESH, BASKET

DESIGN AJS **DART AEROSPACE LTD** DRAWN JPH HAWKESBURY, ONTARIO, CANADA DRAWING NO. CHECKED REV. A D4020 MFG. APPR. SHEET 3 OF 4 APPROVED TITLE 350 BASKET MESH (BASE) DE APPR. ASKE I VIEGOTI (2010) ART AEROSPACE LTD
COPYRIGHT © 2010 BY DART AEROSPACE LTD
IT IS PRIVATE NO GENERAL MADE BY A OTHER PERSON WITHOUT THE PERSON WITHOUT TO THE PERSON WITHOUT THE PERS DATE 10.03.04

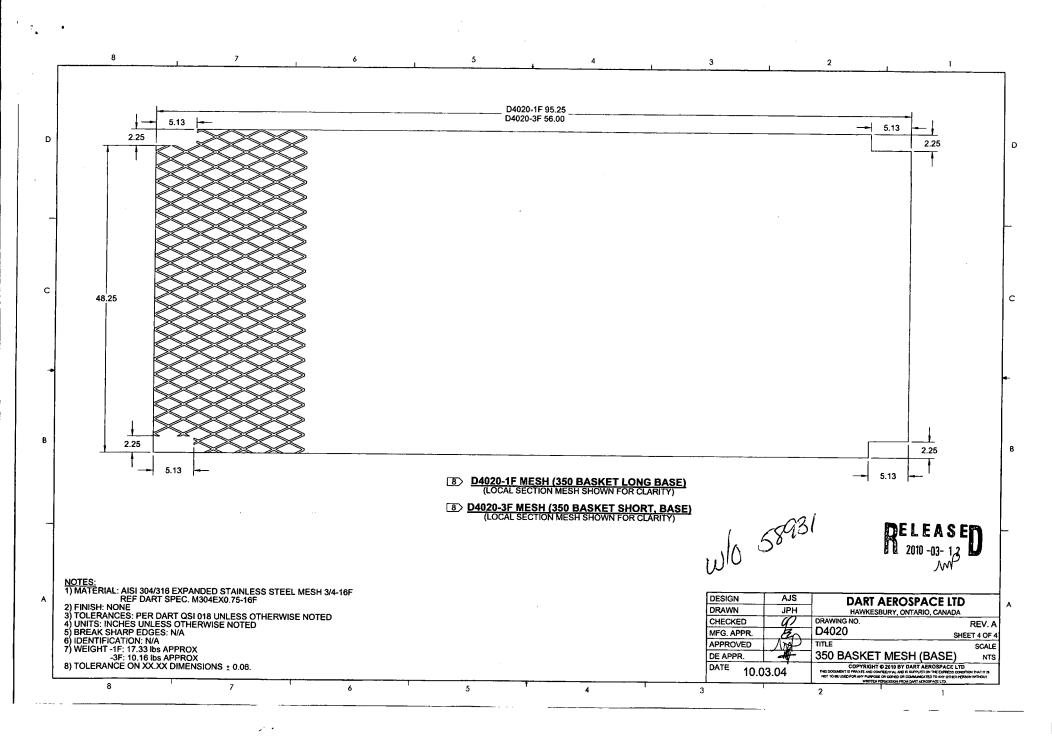
NOTES: 1) MATERIAL: AISI 304/316 EXPANDED STAINLESS STEEL MESH 3/4-16F REF DART SPEC. M304EX0.75-16F

REF DART SPEC. M304EX0.75-16F
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: N/A
6) IDENTIFICATION: N/A
7) WEIGHT: 1.22 lbs
8) LOCAL TRIM MAY BE NECESSARY TO CLEAR FASTENERS/STRUCTURE SEE NEXT ASSY FOR DETAILS
9) TOLERANCE ON XX.XX DIMENSIONS ± 0.06.

8

3

W/O:		(B)	WC	RK ORDER CHANG	ES		••		, .
DATE	STEP	PROCEDURE CHANGE			Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
		9449						Prod Migr	<u>'</u>
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Part No:		PAR #:	Fault Cate	NCR: Yes No DQA: Date:					
	Res	solution:	Disposition	n:	_ QA: N/C Cld	sed:	Date:		
NCR:			WORK ORD	R NON-CONFORMA	NCE (NCR)			
DATE	STEP	Description of NC Section A	Corrective Action Section			Verific	cation	Approval	Approvai
			Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section		Chief Eng	QC Inspector
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W/O:		WORK ORDER CHANGES										
DATE	STEP	PROCEDURE CHANGE			Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector			
Part No:		PAR #:	Fault Cate	gory:	NCR: Yes No DQA: Date:							
	Reso	olution:	Dispositio	n:	_ QA: N/C (Closed:		Date:				
NCR:			WORK ORD	ER NON-CONFORM	ANCE (NC	R)						
DATE	STEP	Description of NC Section A		ion B	Verif	cation	Approval	Approval				
DATE			Initial Chief Eng	Action Description Chief Eng	Sign Dat	& Sec	tion C	Chief Eng	QC Inspector			
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